

Work Order ID 65832

Wednesday, January 26, 2011 11:30:52 AM

Page 1

Item ID: D3016-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Seat Frame Assembly

Start Date: 1/26/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3016

RevA / DEO A-1

100

Weld per dwg A/R 4130 rod Batch: 1000075 0.00
Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig
DT8597

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

5- Assemble brackets and gusset per dwg and weld

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

EL 11-3-30 (X)

1 0 BEI/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Setup Start



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Start Date: 1/26/2011 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/03/30



130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M 11/31/28

Memo

0.00

Powder Coating

Install paint screws on fitting ends

START TIME: 7:40

OVEN TEMPERATURE: 320°

FINISH TIME: 740

1 11/3-31

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 8 M 11/03/31

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Wednesday, January 26, 2011 11:30:52 AM

Page 3

Item ID:	D3016-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Seat Frame Assembly					
Start Date:	1/26/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/7/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo w/o 65831 (M)	0.00 0.00							ES 11/03/31 ①
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/3/31 JF MF 11-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:30:57 AM

Page 1

Work Order ID: 65832

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly





Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 01.09.19 New issue EC IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.049 		Purchased	No			100	f	105.5417	4.3	4.526316			
4130 RD Tube .750 x.049W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		105.5417							
				10133		13							
				110740		92.5417							
M4130NT0.500W.049 		Purchased	No			100	f	58.2830	4.3	4.526316			
4130 RD Tube .500 x.049W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT032		58.283							
				106651		11.75							
				110740		46.533							
M4130NT1.000W.120 		Purchased	No			100	f	15.8400	1.5	1.578947			
4130 RD Tube 1.00 x .120wall													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		15.84							
				113665		15.84							
D3016-17 		Manufactured	No			100	Each	10.0000	2	2			
Gusset													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
				39641		4							
				64618		6							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, January 26, 2011 11:30:58 AM

Work Order ID: 65832

Parent Item: D3016-041



Parent Item Name: Seat Frame Assembly

Start Date: 1/26/2011



Required Date: 2/7/2011

Start Qty: 1.00



Required Qty: 1.00

D3016-13	Manufactured	No	100	Each	14.0000	2	2
							EL 11-3-29
Bracket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	14	
44778	14	

D3016-15	Manufactured	No	100	Each	5.0000	2	2
							EL 11-3-30
Gusset							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	5	
43413	5	

D3020-1	Manufactured	No	100	Each	33.0000	4	4
							EL 11-3-29
Fitting							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	33	
36713	33	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65832

2/11/01-26

DEO ATTACHED

RELEASED
01.05.30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

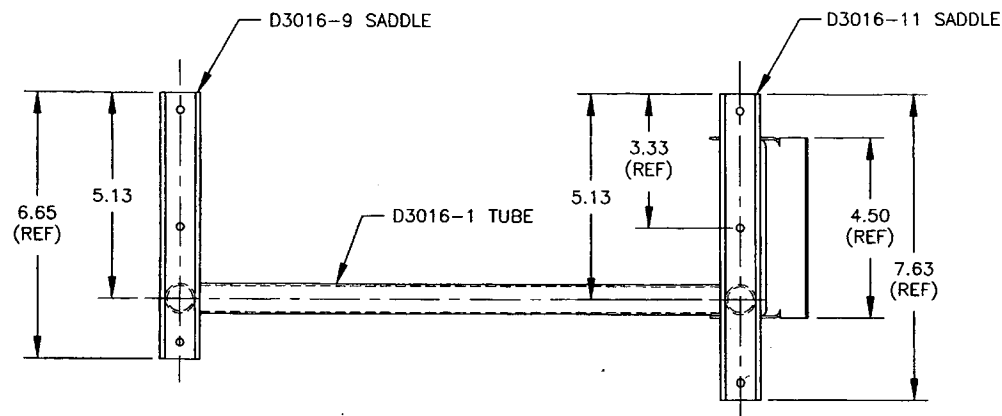
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

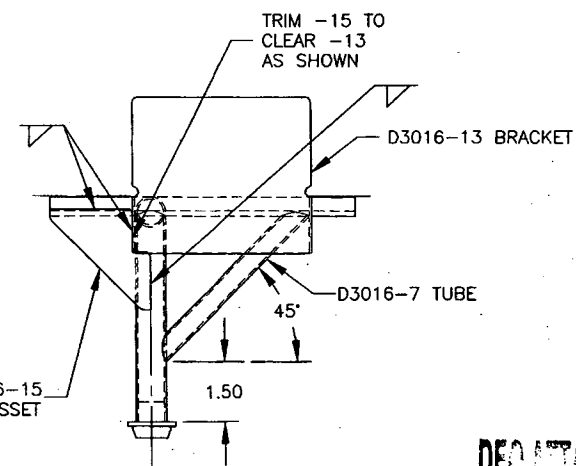
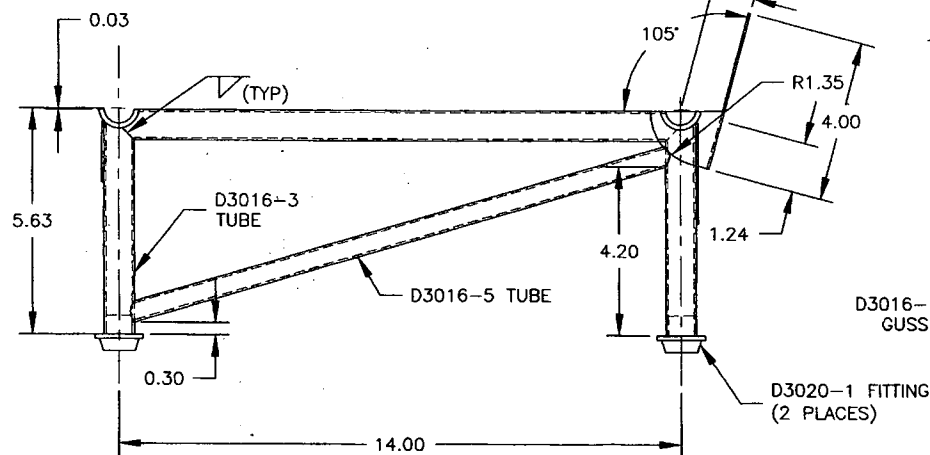
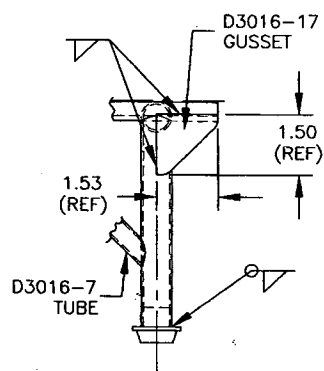
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D3016-041 SEAT FRAME ASSEMBLY



WLO 65832



DETACHED
RELEASED
01.05.30

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DATE		01.05.18		DRAWING NO.	REV. A
				D3016	SHEET 2 OF 3
				TITLE	SCALE
				SEAT FRAME ASSEMBLY	1:3

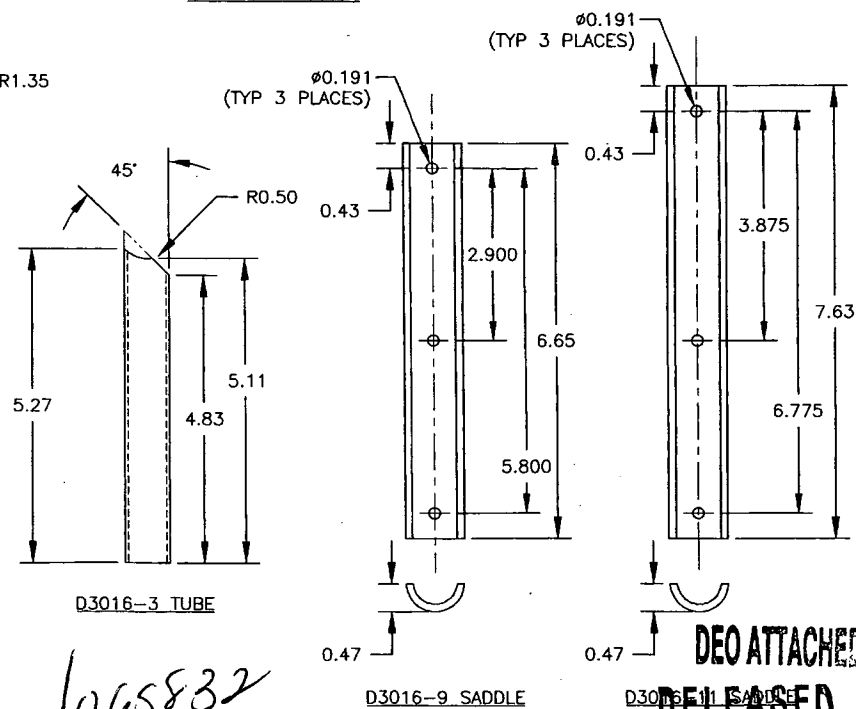
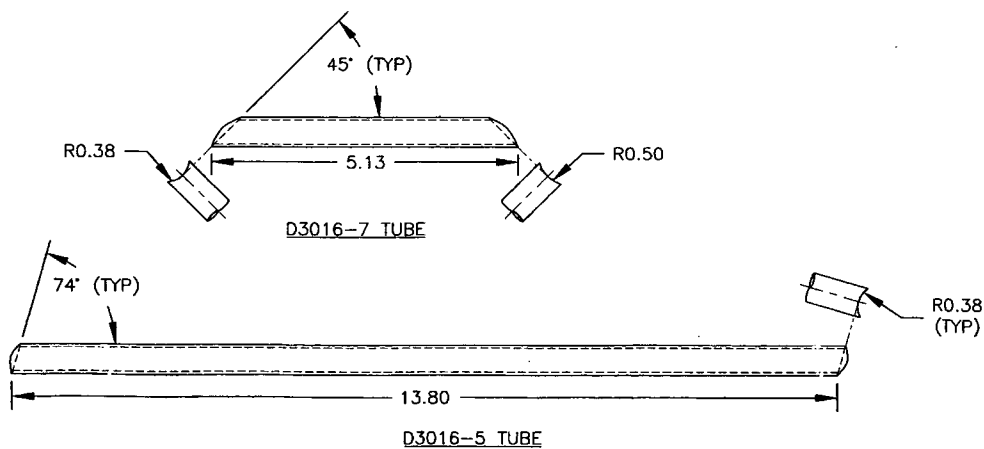
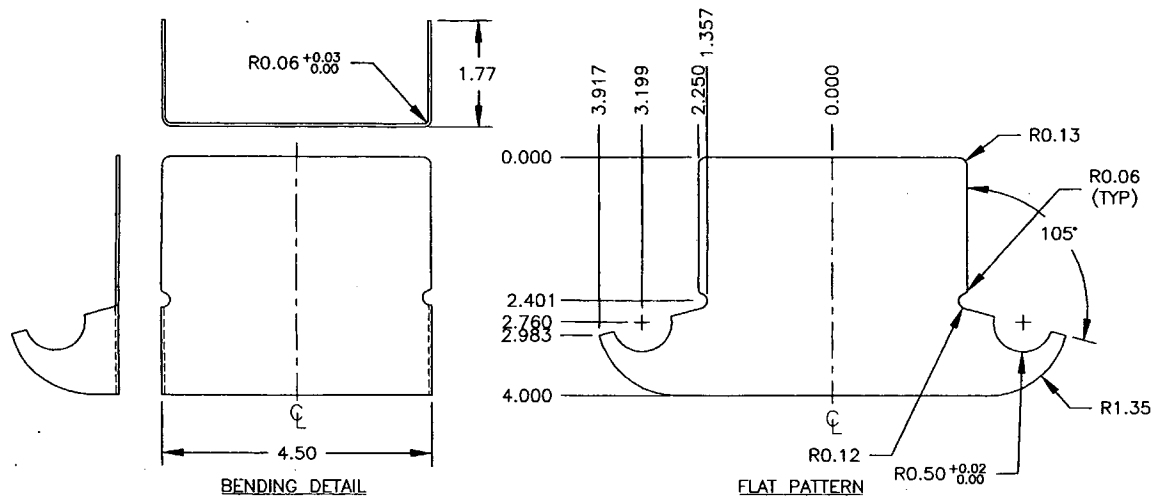
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN	CP	DRAWN BY	CP	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3016	REV. A SHEET 3 OF 3
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	SCALE	1:2

1065832

DEO ATTACHED
RELEASED
9.05.30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>WAP</i>		DE APPR. <i>W</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		DATE 10.01.29		

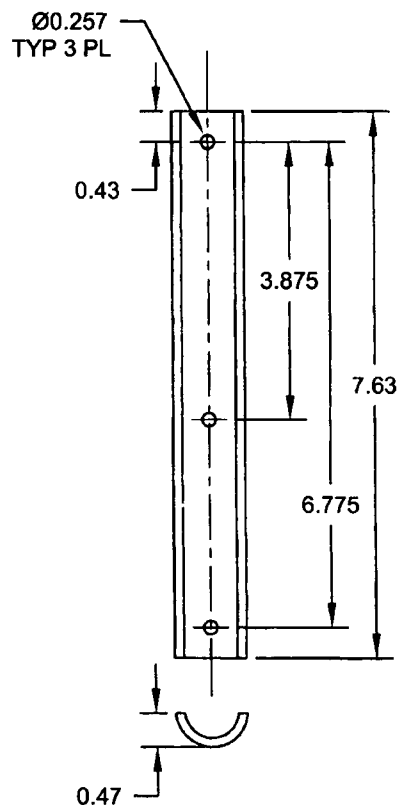
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

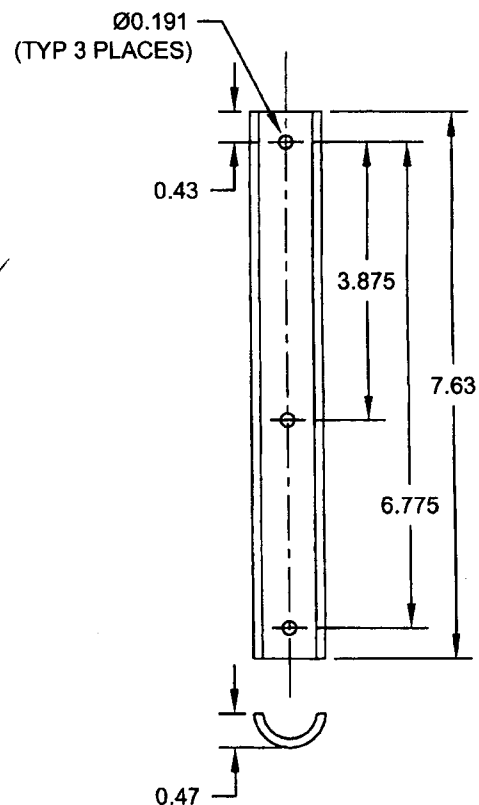
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

w/065832

W/O:		WORK ORDER CHANGES					
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